

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002996**Date Inspected:** 18-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** C. M. Chen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

South Fabrication Bay OBG Assemblies

OBG Assembly Segment 3AE- There are no activities to report. The C5 Side Panel has been CJP splice welded to the bottom plate D6. There are ZPMC UT inspection markings that indicate that the C5 side panel to the D6 bottom panel contains rejectable areas of the CJP splice weld. The E7 side plate has not been fit-up. The Floor beam has been fit-up and welded to the C5 side plate and the D6 bottom plate.

OBG Assembly Segment 3BE- There are surveying activities being performed by ZPMC personnel. The C5 and E7 side panels have been CJP splice welded to the D6 bottom plate and have been found to be compliant by ZPMC UT personnel. The Floor Beam and the longitudinal diaphragms have been fit-up and welded. ZPMC has erected temporary supports for the installation of the deck panels. OBG Assembly Segment 4AE- ZPMC personnel are in process of tack welding the FL1 floor beam to the C5 side plate. The FL2 floor beam has been fit-up and tack welded to the D6 bottom plate. The C5 and the E7 side panels have been CJP splice welded to the D6 bottom plate and have been found to contain non-compliant areas as detected by UT by ZPMC personnel.

OBG Assembly Segment 4BE- ZPMC personnel are in process of preparing the FL1 floor beam CJP splice weld groove on the E7 side plate side to the vertical FL2 web plate. The C5 Side Panel has been CJP splice welded to

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the bottom plate D6 and has been found to contain non-compliant areas as detected by UT by ZPMC personnel. The E7 side plate has not been fit-up.

North Fabrication Bay OBG Assemblies

OBG Assembly Segment 4BW- There are no activities to report. ZPMC has completed the welding of the complete joint penetration groove weld that joins the C5 side plate to the D6 bottom plate. UT by ZPMC of the side plate to the bottom plate CJP splice weld is currently pending UT. The Floor beam has been fit-up and tack welded in place. The E7 side plate has not been fit-up to the opposite side of the assembly.

OBG Assembly Segment 4AW- There are no activities to report. The C5 and the E7 side panels have been CJP splice welded to the D6 bottom plate. The status of the UT of these CJP splice welds is currently pending by ZPMC personnel. The Floor Beam has been fit-up and tack welded to the side and bottom plates.

OBG Assembly Segment 3BW- A ZPMC welder is currently in process of SMAW the FL2 flange plate to the FL1 flange splice welded. The C5 and the E7 side panels have been CJP splice welded to the D6 bottom plate and have been found to contain non-compliant areas as detected by UT by ZPMC personnel. There are surveying activities being performed by ZPMC personnel.

OBG Assembly Segment 3AW- ZPMC welders were observed applying cap weld passes to the B side of the CJP splice weld that joins the bottom plate to the C5 side plate.

General Note: All work observed today, unless otherwise noted, appeared to generally comply with the contract documents.



Summary of Conversations:

No relevant conversations spoken on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Pat Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

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Inspected By: McClendon, Timothy

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer